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SPLIT

DART AEROSPACE LTD	Work Order:	21843 A
Description: Bearpaw Kit (23" x 19")	Part Number:	K10010
Dwg: D2421 Rev. F1	Qty:	510 Kits 1
Ref: K10010 Rev. A; DSK086-4 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																												
1	DC	Issue Traveler Note: (1) K10010 Kit consists of Qty (2) D2421 Dwg not required	HJ	04.11.02	5																																												
2	DC	Photocopy bluefile: K10010 D900-619-011 D105-645-011 and create labels per PPP K10010 CHG003 (Bag Bluefiles separately)	UK 47 HJ DH	04.11.04	10																																												
3	GA	Cut 2 blanks per (1) K10010 Kit Cut blank: 19.50" x 23.50" x 1.00" thick (+0.030/-0.000) per DSK086-4 Material: Black UHMW 1" (MUHMWB10) Batch: <u>115926</u>	ML	04/11/02	5																																												
4	MV	Inspect material for defects or damage prior to machining	ML	04/11/02	5																																												
5	MV	Machine as per Folio FA124 and Dwg D2421 Identify as D2421	ML	04/11/02	2																																												
6	QC2	Inspect parts as they come off the CNC machine	ML	04/11/02	2																																												
7	MV	Deburr	ML	04/11/03	2																																												
8	QC8 & 5	Second inspection	EP	04/11/04	2																																												
9	KP	Pick: Packing Kit (Note: D2421 is on the BOM as material from step 3) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>4</td><td>D2182B060</td><td>Rubber Cushion</td><td>B2185</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B21585</td></tr><tr><td>2</td><td>D2421</td><td>Bearpaw</td><td>B21843</td></tr><tr><td>4</td><td>D2519</td><td>Clamp</td><td>B4649</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B21587A</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>M15321</td></tr><tr><td>8</td><td>AN960JD416</td><td>Washer</td><td>M15321</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15020</td></tr><tr><td>4</td><td>QS100M24S</td><td>Clamp</td><td>M1721</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table>	Qty	Part Number	Description	Batch	4	D2182B060	Rubber Cushion	B2185	8	D2274	Radius Block	B21585	2	D2421	Bearpaw	B21843	4	D2519	Clamp	B4649	8	D2529	Washer	B21587A	8	AN4-15A	Bolt	M15321	8	AN960JD416	Washer	M15321	8	MS21042L4	Nut (or -4)	M15020	4	QS100M24S	Clamp	M1721	1	Paperwork package from Step 2					
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1	Paperwork package from Step 2																																																
10	QC4	Inspect Kit for 100% Completeness on the W/O	KL	04-11-04	1																																												
11	PK	Identify and pack for shipping as per PPP K10010 Rev. B	CL	04/11/05	1																																												
12	AC	Cost / part <u>213.08</u>	54C	04-11-08	1																																												
13	DC	Close W/O <u>207.37</u> Inspect Level 21	HJ	04.11.10	1																																												

Rev	Date	Change	Revised By	Approved
A	00.03.21	K10010 created for Bearpaw (MPP 2037)	EC	
B	03.05.26	Reformat; Incorporated D2421	KJ/RF	
C	04.02.17	Blank size changed on Step 3	KJ/JLM	

04-11-08 RB

RELEASED

D:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

CR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	21843
Description: Bearpaw		Part Number:	D2421
Inspection Dwg: D2421	Rev: F1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

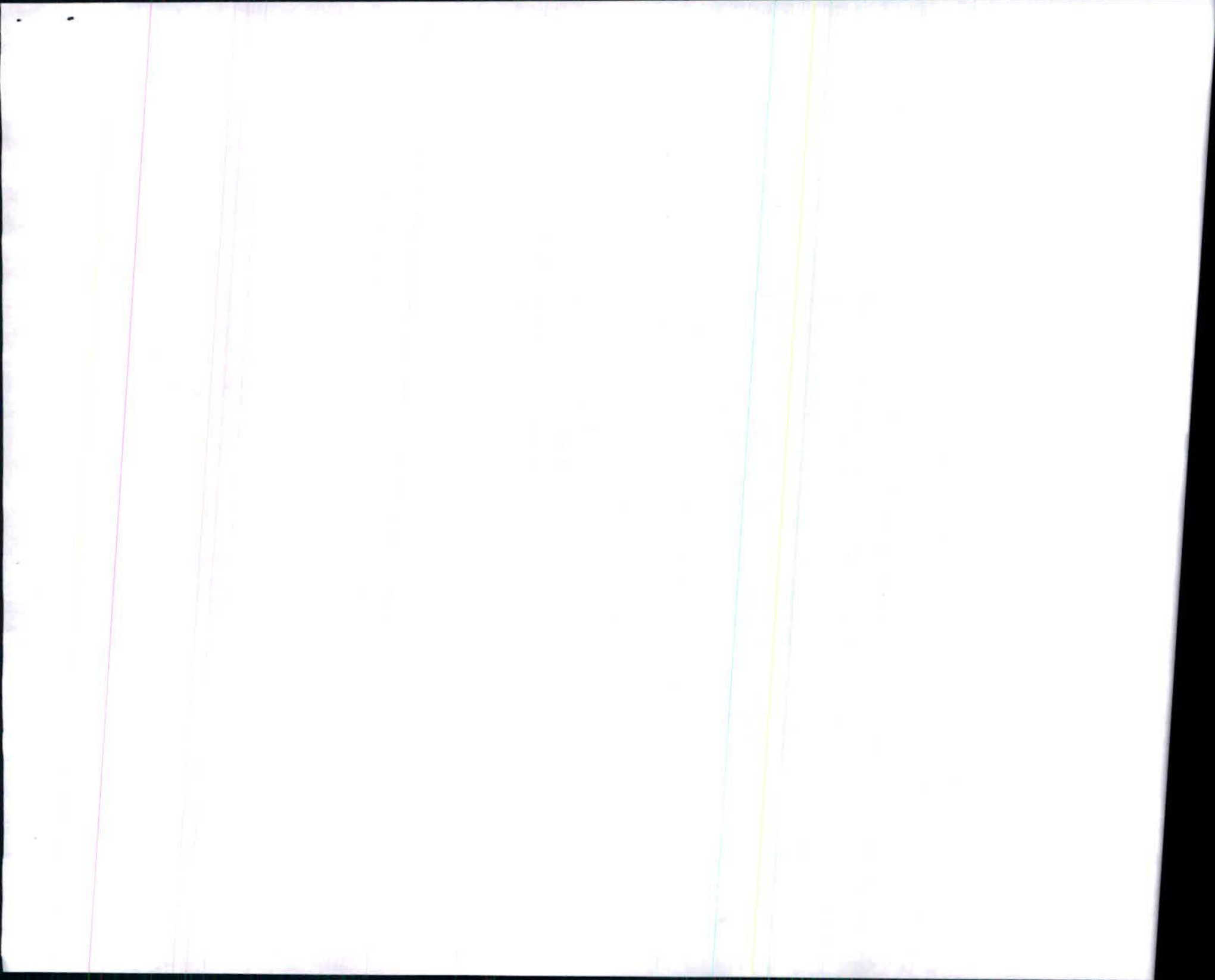
☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.20	+/-0.030	0.197	✓		Uern	
B	0.95	+/-0.030	0.940	✓		Uern	
C	0.45	+/-0.010	0.448	✓		Uern	
D	0.07 x 45°	+0.030/-0.010	0.06x45°	✓		Uern	
E	0.69	+/-0.030	0.696	✓		Uern	
F	0.38	+/-0.010	0.378	✓		Uern	
G	0.44 - 0.47	+/-0.000	0.456	✓		Uern	
H	R0.25	+/-0.030	R0.25	✓		R-G	
I	0.19 x 45°	+/-0.030	0.175x45°	✓		Uern	
J	23.00	+/-0.030	23.015	✓		M-Tape	
K	Ø0.260	+0.005/-0.000	Ø0.260	✓		Uern	
L	Ø0.93	+/-0.030	Ø0.927	✓		Uern	
M	0.40 0.300	+0.030/-0.000	0.408	✓		Uern	
N	4.50	+/-0.030	4.50	✓		Uern	
O	9.50	+/-0.030	9.50	✓		Uern	
P	1.00	+/-0.030	1.000	✓		Uern	
Q	14.750	+/-0.010	14.750	✓		Uern	
R	0.38	+/-0.030	0.385	✓		Uern	
S	4.54	+/-0.010	4.540	✓		Uern	
T	19.00	+/-0.030	19.000	✓		M-Tape	

Measured by:	<i>me</i>	Audited by:	<i>CP</i>	Prototype Approval:	N/A
Date:	04/11/03	Date:	04/11/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	<i>[Signature]</i>

P/O K10010



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 02, 2004
02:36 pm

Work Order No	: 0021843	Department Code:	
Project Name	: K10010	Burden Flags	: NNNNNNNN
Project For	: WK449	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *K10010	Invoice Number	:
Description	: Bearpaw kit for 23 x 19"	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 105	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-02-04		
Est Finish Date	: 11-30-04	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00